

Date: Friday, 6/1/2007 1:02:24 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WEARPLATE
Job Number	32736		
Estimate Number	12731		
P.O. Number	N/A	Part Number	D353535
This Issue	6/1/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D3535 UNDER REVIEW
First Issue	N/A	Project Number	N/A
Previous Run	31992	Drawing Revision	AB
Written By		Material	N/A
Checked & Approved By		Due Date	6/8/2007
Comment	Est Rev: A New Issue 07-02-15 JLM	Qty:	20
Um:	Each		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S20GA	304/316 .040 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.8423 sf(s)/Unit Total : 16.8462 sf(s)

304/316 .040 Sheet

(M304S20GA) (19)

Batch: M101873 M103713 (1)

ml 07 06 04

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: B

Prog Rev: B

SAD 07106105

(20)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Deburr if necessary

2-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326.

3-Identify as D3535-35.

SP 07/06/12

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/26/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 6/1/2007 1:02:24 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 32736

Part Number: D353535

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



*7-06-12 (20)*

Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING

POWDER COATING



*M 101601*



*(20)*

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*PR*

*07-06-13*

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*(20X)*

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*M.d 07/06/13*

9.0 PACKAGING 1

PACKAGING RESOURCE #1



*(20X)*

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*EP 15*

*M.d 07/06/13*

10.0 QC21

FINAL INSPECTION/W/O RELEASE



*(20)*

Comment: FINAL INSPECTION/W/O RELEASE

*07/06/14*

Job Completion



*07/06/14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

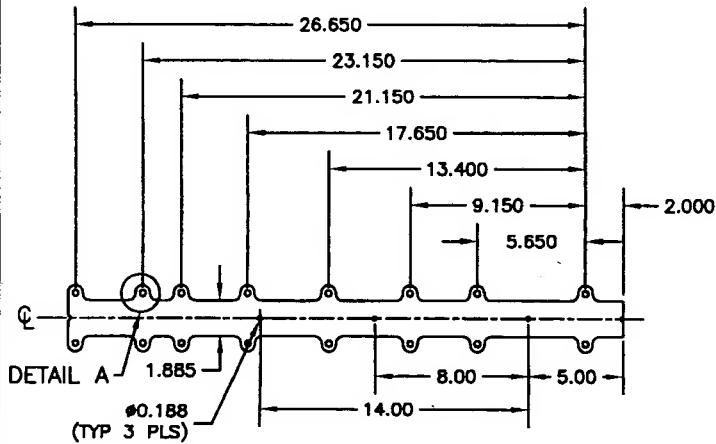
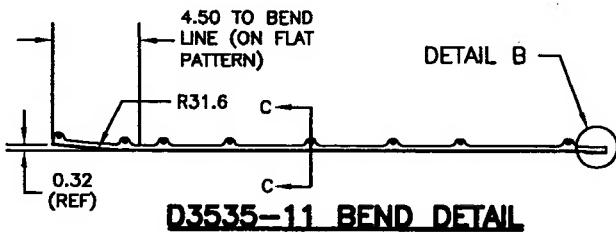
DART AEROSPACE LTD	Work Order:	32736
Description: Wearshoe	Part Number:	D3535-35
Inspection Dwg: D3535	Rev: B	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	M. M	Audited by:	<u>  </u>	Prototype Approval:	N/A
Date:	07/06/04	Date:	07/06/04	Date:	N/A

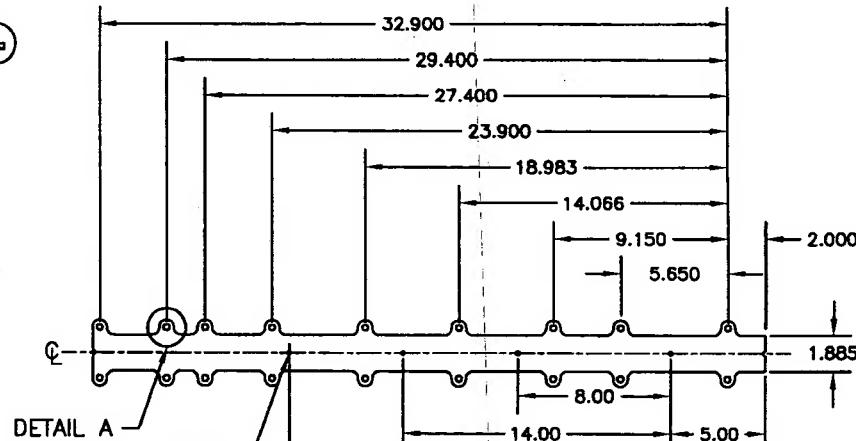
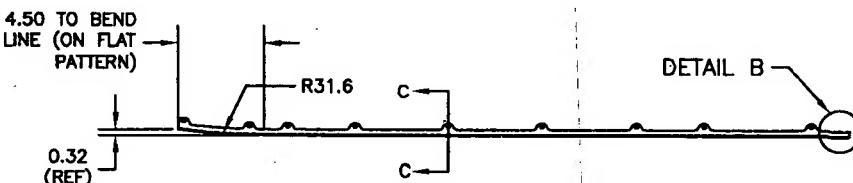
Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM <i>✓</i>	<i>E</i>

**DART****D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL**

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WITHOUT NOTICE  
WORK ORDER  
NO 32736

**NOTES**

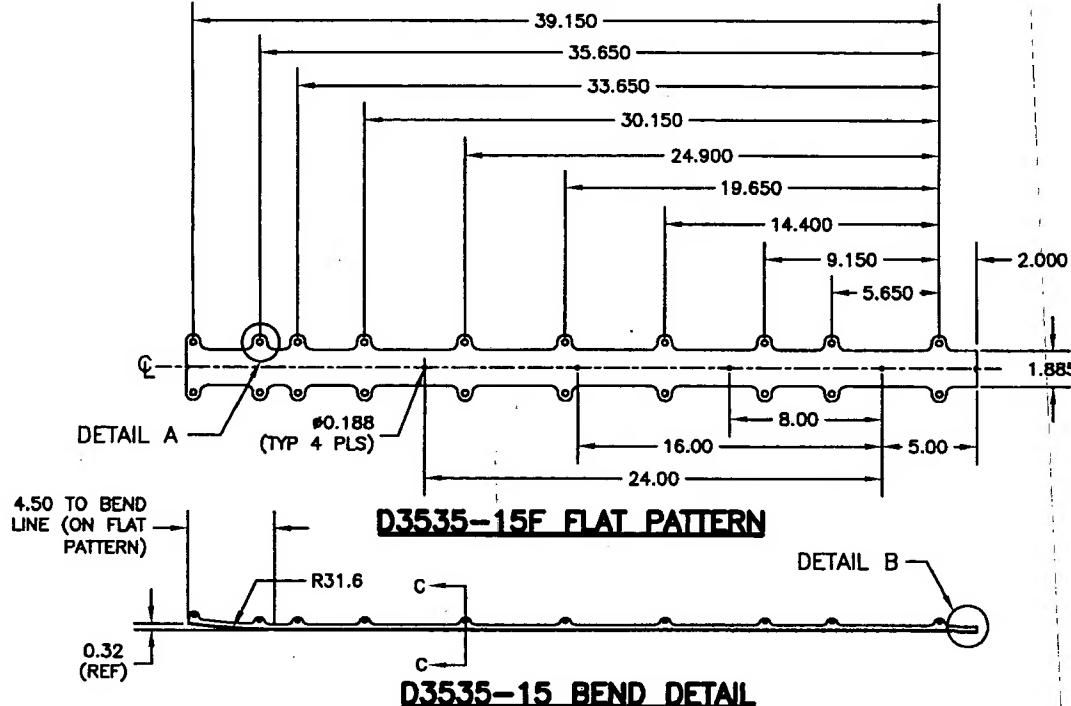
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524.  
20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER  
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT  
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

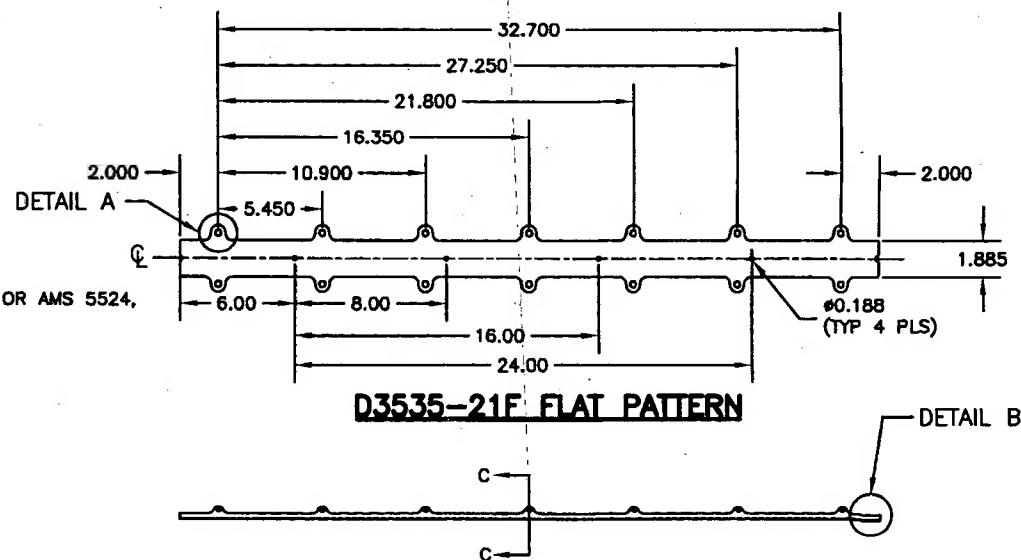
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<i>PH</i>	<i>PH</i>	D3535
07.04.17		TITLE
A	06.10.25	WEARSHOE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

REV. B  
SHEET 1 OF 7  
SCALE 1:10

RELEASED  
57-04-24  
*[Signature]*

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07.04.24

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		1:10



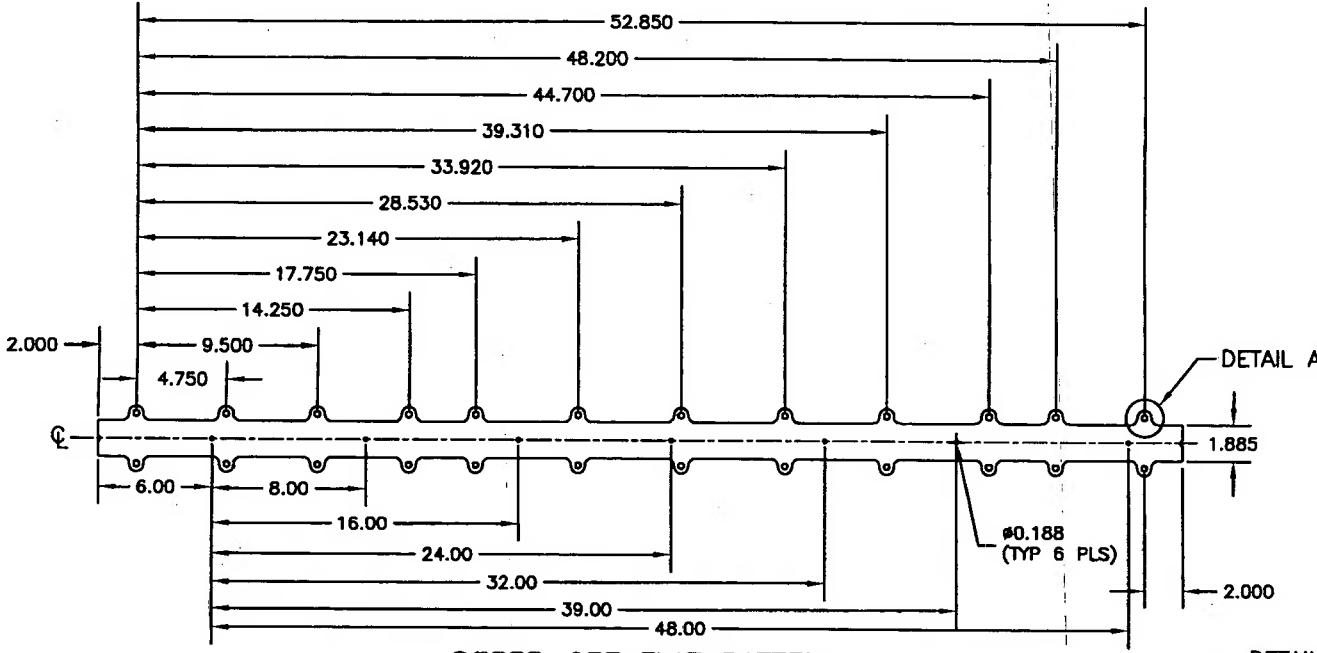
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WORK ORDER # 32936

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- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
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- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
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<i>MM</i>	<i>MM</i>	D3535
DATE		TITLE
07.04.17		WEARSHOE

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07.04.24 *MM*

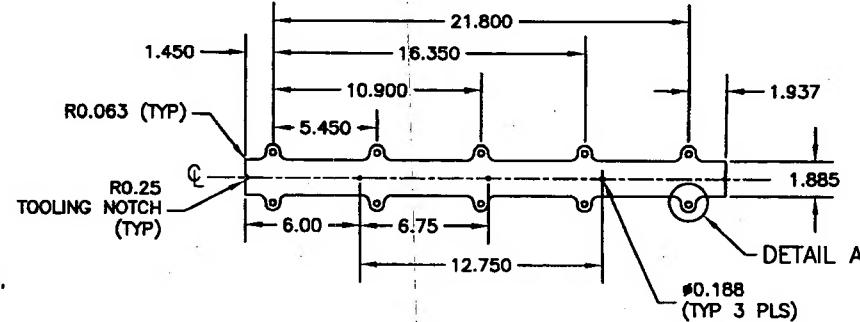


**D3535-23F FLAT PATTERN**

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**NOTES**

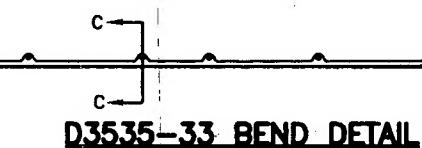
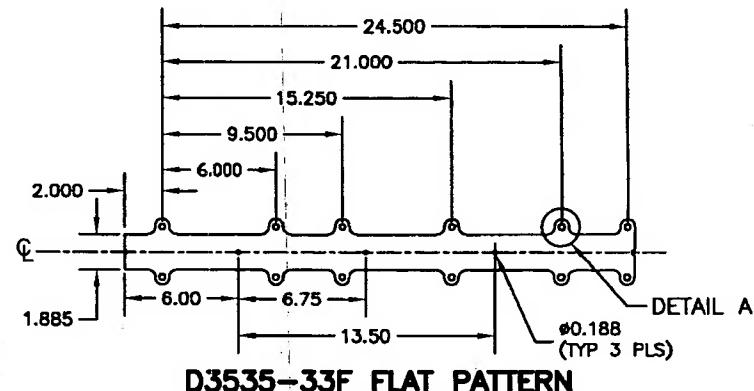
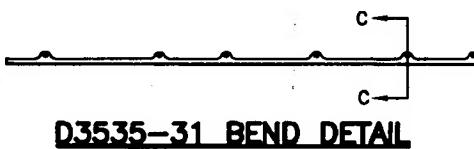
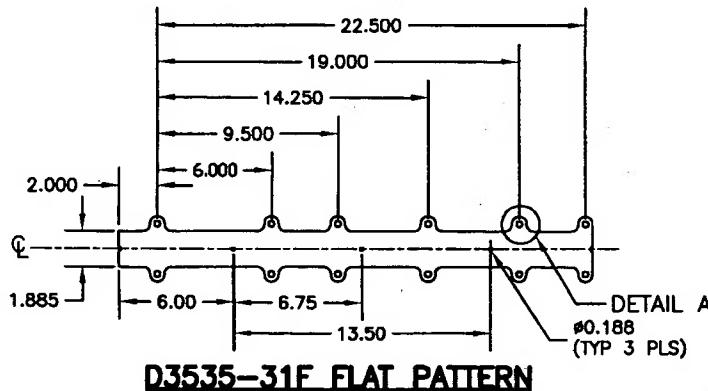
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
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**D3535-25F FLAT PATTERN**



**D3535-25 BEND DETAIL**

**DART**RELEASED  
07.04.24**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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DATE		WEARSHOE
07.04.17		

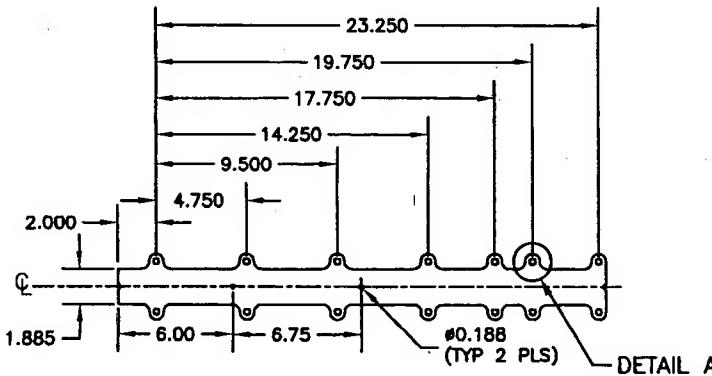
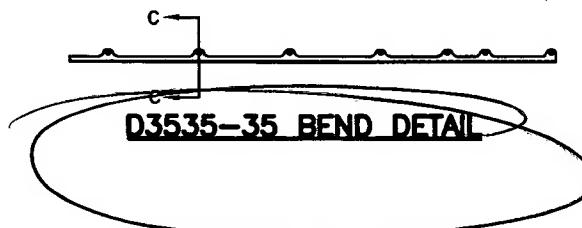
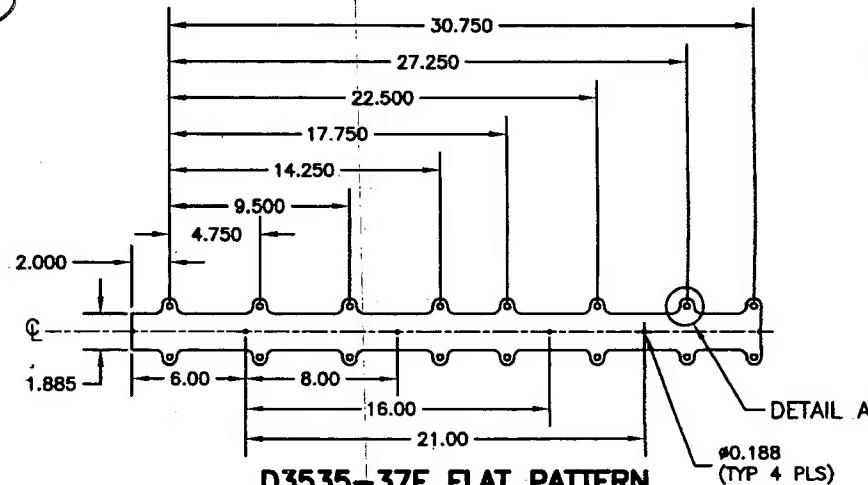
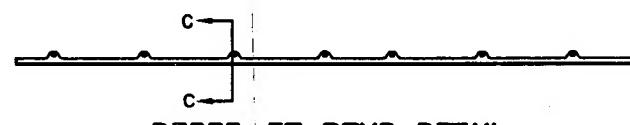
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**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL****D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

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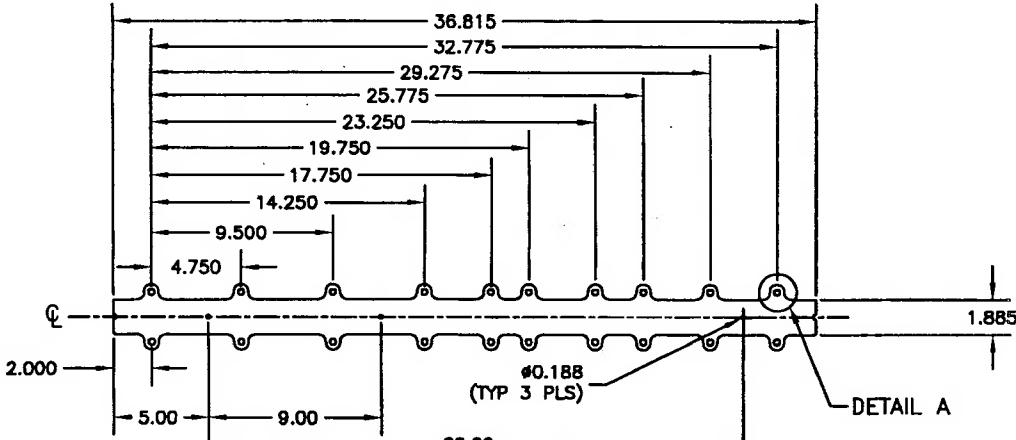
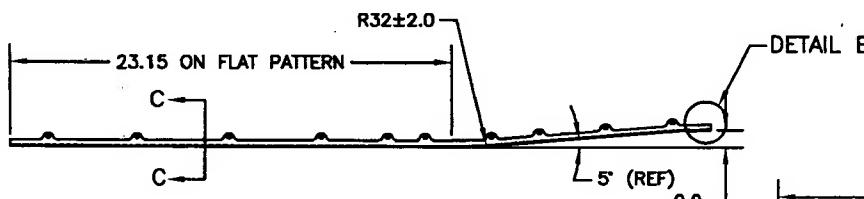
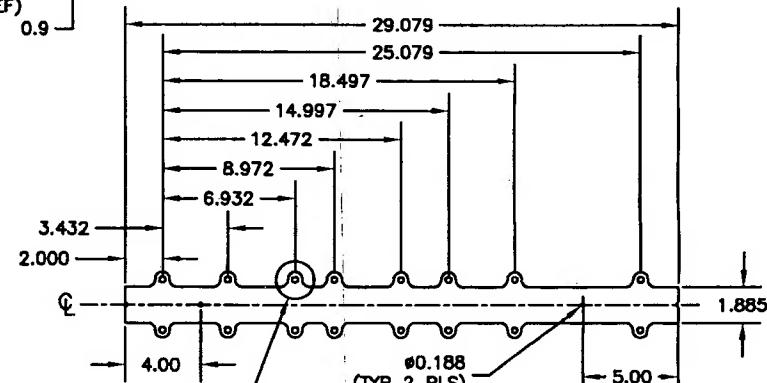
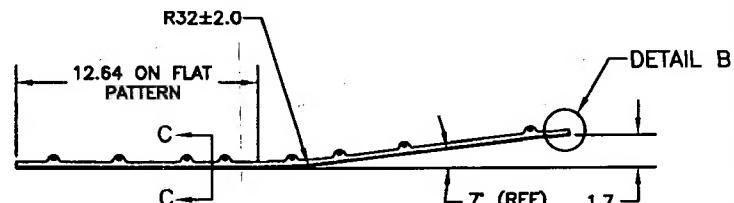
**NOTES**

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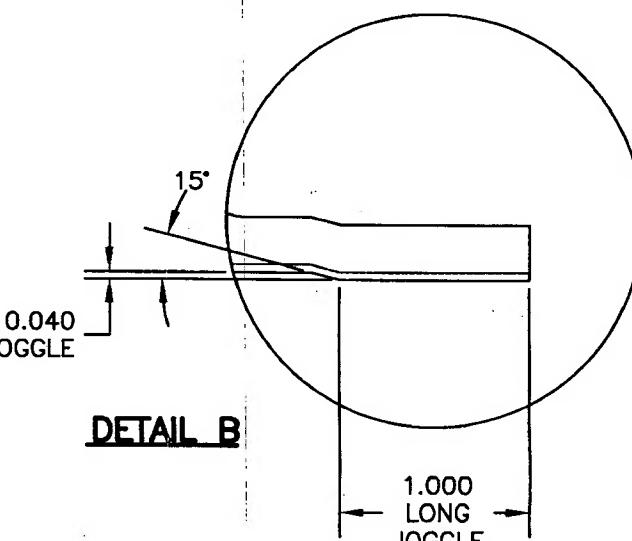
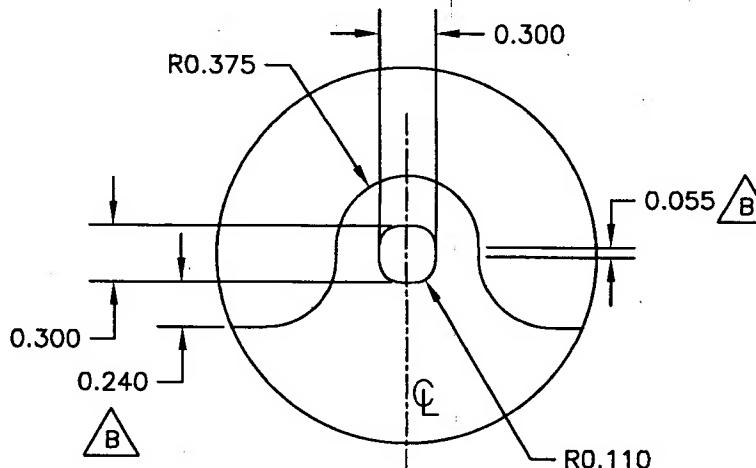
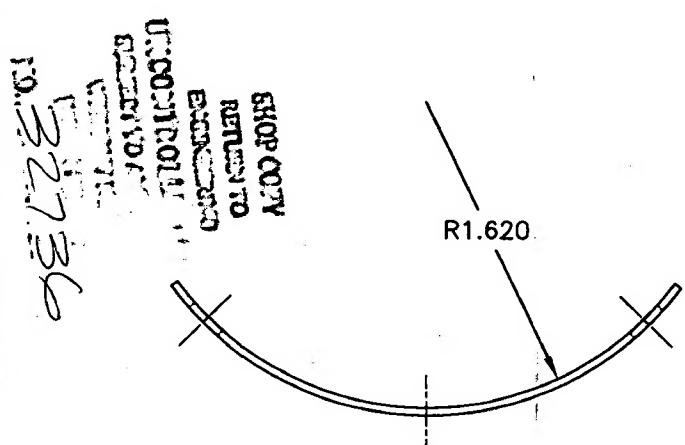
**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL**

NOTES  
 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,  
 20 GAUGE (0.038 THICK)  
 (REF DART SPEC M304S20GA)  
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 3) PART IS SYMMETRICAL ABOUT Q  
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DATE		SCALE
07.04.17		1:1
	WEARSHOE	

**DETAIL B****DETAIL A****SECTION C-C**

10.327.36

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